

Work Order ID 75299

October-20-11 9:58:55 AM

75299


Page 1

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.S Date: 11/10/20 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2989	Rev D								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs in DT9446 jig, weld as per dwg D2989 2- tack weld mesh on basket as per dwg D2989 using DT9446 jig 3- to locate hinges and shims use D2989-041, weld as per dwg D2989 A/R ER316 S.S. Rod Batch: <u>121602</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.00							
Quality Control									

CC / PC 12.7.17

1 φ  *12.07.17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	DAS 16 8-8	12(5)17					
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.00							1 16 12-7-17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to powder coating								
	2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989								
	1ST COAT								
	START TIME: <u>1:30</u>								
	OVEN TEMPERATURE: <u>400°F</u>								
	FINISH TIME: <u>2:03</u>								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: _____								
	OVEN TEMPERATURE: _____								
	FINISH TIME: _____								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

W121841

IX 12/07/17

1 12/27-17

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>D350-607-043A</i>	0.00							
150									
Packaging	Memo	0.00				<u>1</u>	<u>0</u>	<u>1210717</u>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

ML 12/07/19
ME
12-07-19

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Picklist Print

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Page 1

Work Order ID: 75299

75299

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 *D2221-1* Rib		Manufactured	No			100	Each	16.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				16					
				71372				4					
				72297				12					
D2989-3 *D2989-3* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
				71551				1					
				72408				3					
D2989-4 *D2989-4* Rib		Manufactured	No			100	Each	4.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>					
				WA				4					
				71550				1					
				72409				3					

**

**

**

PL 12.7.17

383907 → ①

PL 12.7.17

377527 → ①

PL 12.7.17

377524 → ①

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Work Order ID: 75299

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Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2989-5 Manufactured No

100 Each 9.0000 2 2

D2989-5

Rib

**

Location

Loc Qty

Loc Code

WA

9

71222

9

D3182-1 Manufactured No

100 Each 6.0000 2 2

D3182-1

Hinge

**

Location

Loc Qty

Loc Code

WA

6

71223

6

D3442-3 Manufactured No

100 Each 11.0000 2 2

D3442-3

Shim

**

Location

Loc Qty

Loc Code

WA005

11

70671

11

D3827-041 Manufactured No

100 Each 9.0000 1 1

D3827-041

Rib Assembly (Inboard)

**

Location

Loc Qty

Loc Code

WA

9

72083

3

72729

6

PL12.7.17

B81911 → ②

PL12.7.17

B77316 → ②

PL12.7.17

B80708 → ②

PL12.7.17

B84792 → ①

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 75299

75299

Parent Item: D2989-043

D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3832-5 Manufactured No

100 Each 5.0000 1 1

D3832-5

Mesh (Lid)

**

Location

Loc Qty

Loc Code

WA

5

71302

2

73638

3

D3833-5 Manufactured No

100 Each 48.0000 2 2

D3833-5

Mesh (Lid End)

**

Location

Loc Qty

Loc Code

WA

48

67461

48

D3838-041 Manufactured No

100 Each 4.0000 1 1

D3838-041

Rib Assembly (Basket Lid, LH)

**

Location

Loc Qty

Loc Code

WA

4

71744

1

72414

3

D3838-042 Manufactured No

100 Each 4.0000 1 1

D3838-042

Rib Assembly (Basket Lid, RH)

**

Location

Loc Qty

Loc Code

WA

4

71740

1

72415

3

Pl 12.7.17
B73748 → ①
77756

Pl 12.7.17
B67461 → ②

Pl 12.7.17
B77525 → ①

Pl 12.7.17
B77526 → ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 75299 *M.L.S.*
11/10/20

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/18

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-17; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3836 DWG); D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2989 TITLE BASKET LID ASSEMBLY COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	DS		
CHECKED	DS		
MFG. APPR.	DS		
APPROVED	DS		
DE APPR.	DS	REV. D SHEET 1 OF 5 SCALE NTS	
DATE	08.09.24		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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SECTION B-B D7-2

4.16 REF

30.00

34.50

30.00 REF

D2581 MOUNTING BRACKET 2 PL

D2506 LABEL PLATE CENTER ON BASKET LID

D2989-17 RIB

D3852-041 RIB ASSEMBLY REF

D2989-19 RIB

D2989-13 RIB

D2512-7 RIB

D3852-042 RIB ASSEMBLY REF

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

SKIN BASKET LID WITH D3832-3 MESH TACK WELD EACH END STRAND TO EXTERNAL FRAME

TACK WELD MESH TO LABEL PLATE AT EVERY AVAILABLE LOCATION

TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID PAINT THIS SECTION

SECTION A-A A4-2

D3833-3 MESH, LID END

D3852-041 RIB ASSEMBLY

D3836-041 RIB ASSY

TRIM MESH LOCALLY AS REQUIRED 2 PL

31.94

32.13 REF

96.00 REF

31.94

D2989-13 RIB REF

D2989-13 RIB REF

D3833-3 MESH, LID END

D3852-042 RIB ASSEMBLY

D3836-042 RIB ASSY

TRIM MESH LOCALLY AS REQUIRED 2 PL

VIEW A:A B8-2

2 PL

FILL NOTCH WITH WELD 9 PL

RELEASED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
DRAWN			SHEET 2 OF 5
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
DATE	08.09.24	BASKET LID ASSEMBLY	

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RELEASED
08/11/18

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D2989	SHEET 2 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD <small>*THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE, LTD.</small>	

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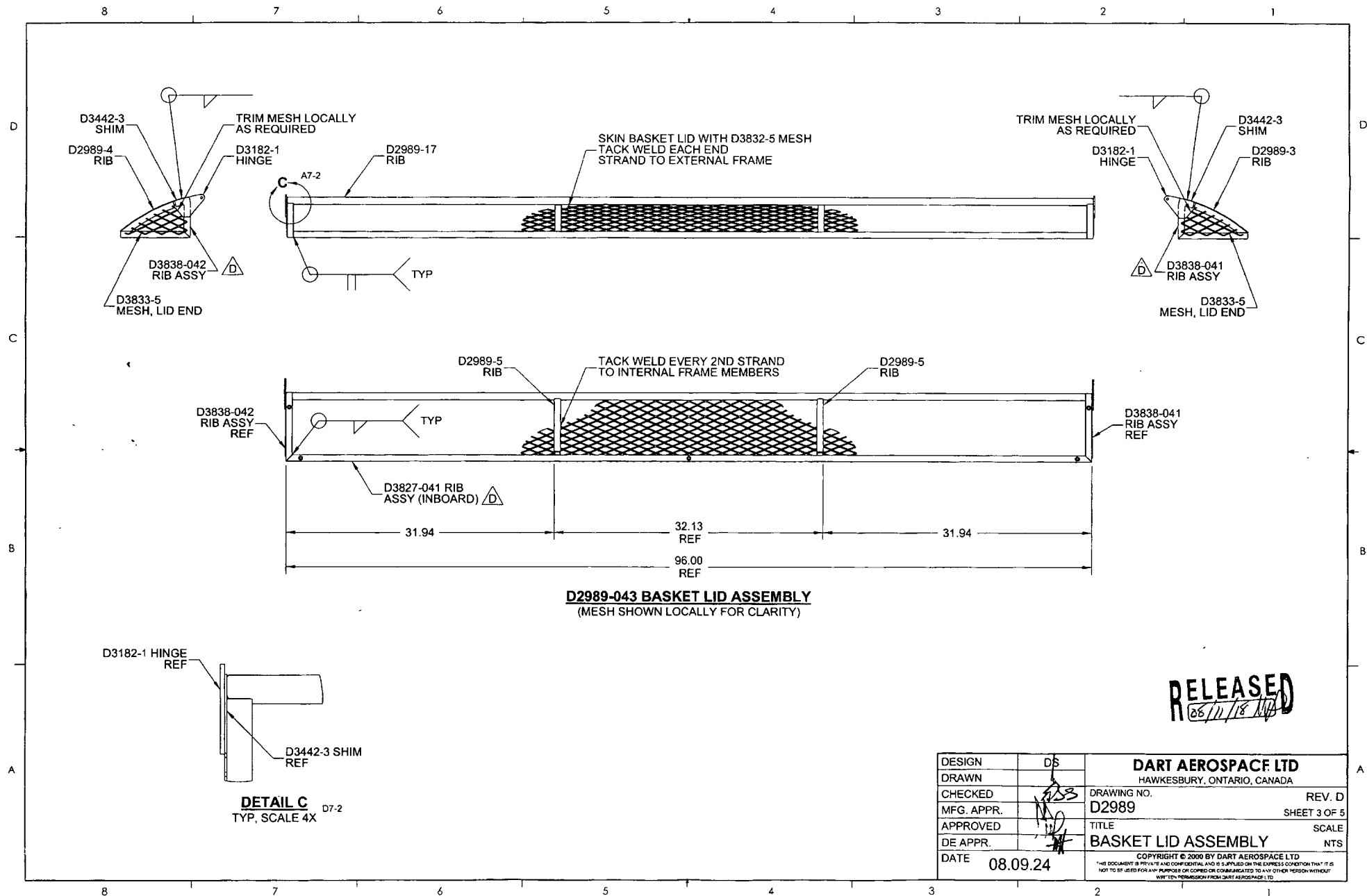
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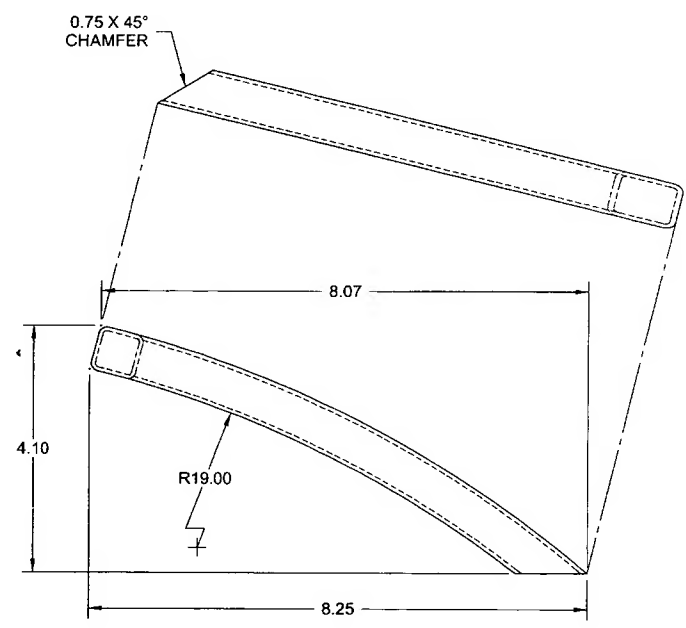
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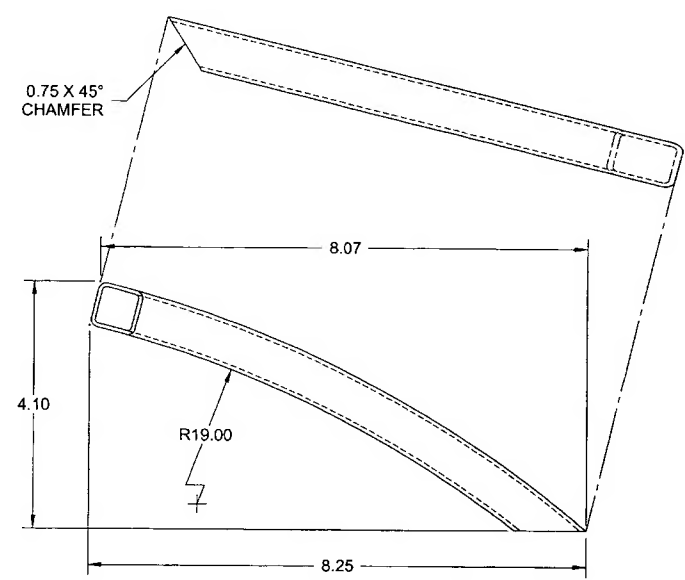
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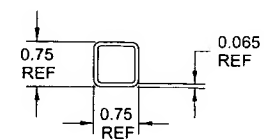
75299



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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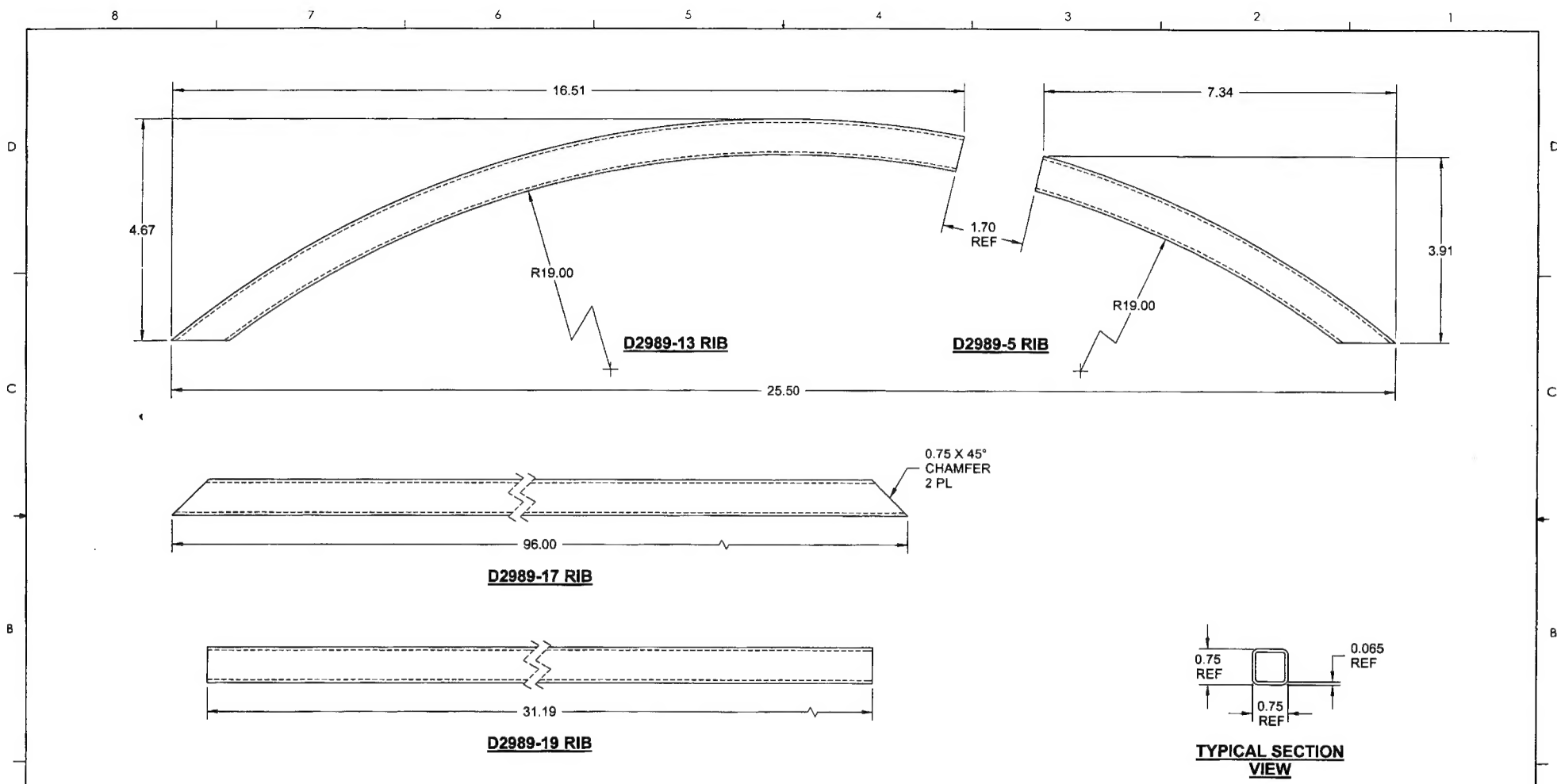
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- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

RELEASED
08/11/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries